

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015793**Date Inspected:** 24-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:** **Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:** **Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:** **Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:** **Yes No N/A****Delayed / Cancelled:** **Yes No N/A****Bridge No:** 34-0006**Component:** Trial Assembly, Bay 4**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Christopher D'souza was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

Trial Assembly

ABF inspection request 07232010 – 1 and 07242010 – 1

9CE – 9DE transverse splice welds

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between 9CE and 9DE transverse splice and corner assembly holdbacks. The weld designations are as follows

OBE9A – 002, 003

OBE9A – 005

CA063 – 006

CA066 – 006

SEG056* - 047

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

by ZPMC MT personnel. This QA Inspector generated a TL-6028 MT report on this date. The weld designation numbers is as follows:

DP 3078-001- 001~010

DP 3119-001- 001~010

QA Inspector performed Final Visual Inspection following the guide lines of AWS-D1.5 on Deck Panel assemblies including Partial Penetration (PJP) welds joining U-ribs to deck plate. The deck panels examined are as follows:

DP 3078-001: Final VT appears to comply with code and contract requirements.

DP 3119-001: Final VT appears to comply with code and contract requirements.

QA Inspector performed Green Tagging activities following the green tagging procedure. The deck panels green tagged are as follows:

DP 3078-001: Green Tag Number 11873

DP 3119-001: Green Tag Number 11874

ZPMC NWIT 06274

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBG component previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QA Inspector observed no rejectable indications at the time of testing. Weld identification numbers were

SEG054C – 006, 024, 026

SEG054B – 001, 011, 013

This QA Inspector generated a TL-6027 UT report on this date.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Dsouza,Christopher
Reviewed By:	Carreon,Albert

Quality Assurance Inspector

QA Reviewer